

# Work Order ID 68293



Page 1

Monday, April 11, 2011 1:18:21 PM

Item ID: D2622-120C

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Extrusion

121

Start Date: 4/11/2011 Start Qty: ~~120.00~~



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 120.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: 11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2622                          | Rev C1                   |                      |         |        |              |               |               |                  |                |

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13848 ☐ a) Extrude as per Dwg D2622 Rev. C ☐ b)  
Material: 6061-T6 (QQ-A-200/8) ☐ c) Minimum yield tensile strength = 35  
ksi ☐ d) Minimum ultimate tensile strength = 38 ksi ☐ e) Minimum elongation =  
8% ☐ f) Order at 120" longg) Bon L Canada Inc.

CL 11104/12 121

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

Puffe/e 126

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2622 for compliance page attached Check hardness  
with Webster tester

Sub 6/08

Sub 6/10

counts  
H76

H70

SPR check

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 68293**

Page 2

Monday, April 11, 2011 1:18:21 PM

Item ID: D2622-120C

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Extrusion

Start Date: 4/11/2011 Start Qty: 120.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

AE / A-E 11-06-09 126

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13 JDCL1106113

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 11, 2011 1:18:28 PM

Page 1

Work Order ID: 68293



Parent Item: D2622-120C



Parent Item Name: Step Extrusion


Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 120.00

Required Qty: 120.00

## Comments:

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120CP<br><br>Extrusion |                        | Purchased     | No          |                     |                  | 110             | Each               | 126.0000       | 1           | 120          |               |                |        |

*Pay/c 120*

### Location

### Loc Qty

### Loc Code

HALL

126

66970

126

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

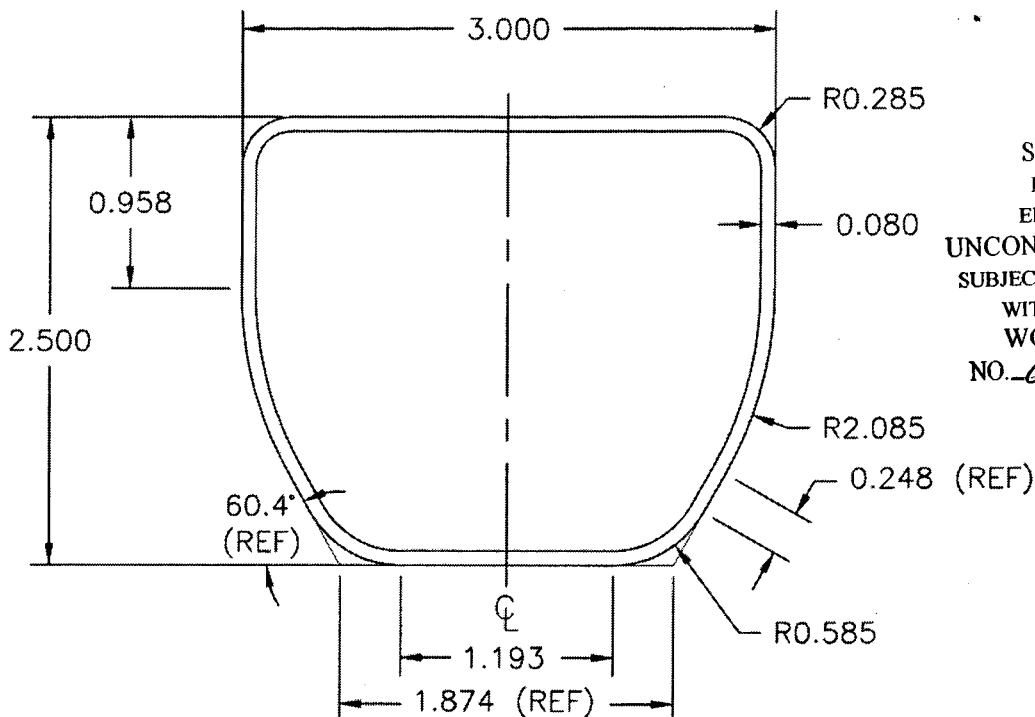
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>GP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D2622                              | REV. C<br>SHEET 1 OF 1 |
| DATE<br>02.09.11 |                | TITLE<br>STEP EXTRUSION                           | SCALE<br>1:1           |
| A                | 96.11.29       | NEW ISSUE   |                        |
| B                | 97.12.12       | CHANGE MATERIAL, ADD TOL. QSI                     |                        |
| C                | 02.09.11       | 0.080 WAS 0.085; ADD PART & DIE No.               |                        |
| C1               | GP 02.10.04    | ADD 'REV. A' TO DIE NUMBER.                       |                        |

RELEASED  
02.09.11 H



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68293

R/110410

#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577

\*\*\*OUTSTANDING PO REPRINT\*\*\*

Purchase Order ID PO13848

Purchase Order Date 4/12/2011

PO Print Date 6/7/2011

Page Number 1 of 1

Order From :

VC-BON001

REFERENCE ONLY

SIGNATURE ALUMINUM  
1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8  
CA

Contact Name  
Vendor Phone 800 563 1079  
Vendor Fax 800 565 8339  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB Destination-Collect

| Line Nbr | Reference<br>Revision ID<br>Vendor Part Number | Description/<br>Mfg ID | Req Date/<br>Taxable | Req Qty | Unit Price | Extended Price |
|----------|--|------------------------|----------------------|---------|------------|----------------|
|----------|--|------------------------|----------------------|---------|------------|----------------|

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

| Line Nbr | Reference<br>Revision ID<br>Vendor Part Number | Description/<br>Mfg ID | Req Date/<br>Taxable | Req. Qty/<br>Unit of Measure | Ship Method | Unit Price | Extended<br>Price |
|----------|--|------------------------|----------------------|------------------------------|-------------|------------|-------------------|
| 3        | D2622-120CP                                    | Extrusion              | 6/10/2011<br>Yes     | 121.00<br>Each               | Yours ppd   | \$27.0657  | \$3,274.95        |

Special Inst: EXTRUDE AS PER DWG D2622 REV.  
C1  
B68293  
MATERIAL: 6061-T6 AS PER QQ-A-  
200/8  
MINIMUM YIELD TENSILE  
STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE  
STRENGTH = 38 KSI  
MINIMUM ELONGATION = 8 %  
120" LONG  
SIGNATURE ALUMINUM TOOL #  
897123

Line Total: \$3,274.95

REFERENCE ONLY

Outstanding PO Total: \$3,274.95

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 4

Change Date: 6/6/2011



# SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD  
PICKERING, ON L1W 3R8

## CERTIFICATE OF COMPLIANCE

| Cert Date  | Cert No | Sales Order | Page     |
|------------|---------|-------------|----------|
| 05/25/2011 | 5262215 | 100762      | 1        |
| Cust PO    | B/L No  | Lot         | Date     |
| 13848      | 001349  | 802084      | 06/04/11 |

| Sold To   | Ship To   |
|---|---|
| 46024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7<br>CANADA | 46024<br>DART AEROSPACE LTD.<br>1270 ABERDEEN ST.<br>HAWKESBURY, ON K6A 1K7<br>CANADA |

| Item No                       | Part No      | Item Description | Cust Part |
|-------------------------------|--------------|------------------|-----------|
| 003                           | DAA-897123-1 | DIE REV. A       | D2622     |
| Gross Weight                  | 1,204 LBS    |                  |           |
| Net Qty                       | 1,173 LBS    | 126 PCS          | 2 PKGS    |
| Specification                 | Die Desc     |                  |           |
| AMS-QQ-A-200/8 & ASTM B221-08 |              |                  |           |

### Mechanical Tests:

| Tensile      | Yield        | % Elongation | Conductivity | HREW |
|--------------|--------------|--------------|--------------|------|
| MPA / KSI    | MPA / KSI    |              |              |      |
| 291.8 / 42.3 | 260.0 / 37.7 | 11.7         | 0.0          | 92   |

### Chemical Analysis:

| SI   | FE   | CU   | MN   | MG   | CR   | ZN   | TI   |
|------|------|------|------|------|------|------|------|
| 0.62 | 0.32 | 0.24 | 0.09 | 0.88 | 0.06 | 0.07 | 0.02 |

*Signature*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

R. Petersen, QA Manager Signature Aluminum Canada Inc



ACCT# 46024

## INVOICING AND COMPANY LOCATION

## SHIPPING MANIFEST

SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8MANIFEST DATE / DATE DU BODEREAU  
06-04-11MANIFEST NUMBER / N° DE BODEREAU  
001349SALES ORDER NUMBER / N° DE COM  
100762

## SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

PHONE: 613-632-5200

## SOLD TO / VENDUE À

DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDANCEREFEREZ-VOUS A CES  
NUMEROUS POUR TOUTE  
CORRESPONDANCE

|  |   |                                     |  |  |                                      |  |                                    |  |                                     |  |  |
|--|---|-------------------------------------|--|--|--------------------------------------|--|------------------------------------|--|-------------------------------------|--|--|
| LOCATION                                     |   | TRAILER NUMBER /<br>REMORQUE Nombre |  | SALESMAN /<br>VENDEUR                    |                                      | CREDIT REP / REP DU CRÉDIT                   |                                    | SALES REP / REP. DES<br>VENTES               |                                     |  |  |
| PIC  |   | PUP                                 |  | 138                                      |                                      |  |                                    | H. CAMERON                                   |                                     |  |  |
| CUSTOMER ID / ID DU<br>CLIENT                |   | ORDER DATE / DE LA<br>COM           |  | CUSTOMER PO NUMBER / CLIENT PO Nombre    |                                      | JOB / FICHIER                                |                                    | FIELD SALES REP / REP<br>REGIONAL DES VENTES |                                     | CUST SERVICE REP / REP.<br>SERVICE CLIENTELE |  |
| 46024  |   | 04/12/11                            |  | 13848                                    |                                      |  |                                    | M. BATES                                     |                                     | cgerard                                      |  |
| BILL OF LADING NUMBER / NO. DE CONNAISSEMENT |   | CARRIER / TRANSPORTEUR              |  |  |                                      |  |                                    |  |                                     |  |  |
| 001349                                       |   | JODEE                               |  |  |                                      |  |                                    |  |                                     |  |  |
| ITEM<br>NO. /<br>NUMÉRO                      | ORIGINAL ORDER<br>QUANTITY /<br>Quantité d'ordre ORIGINAL | UNIT /<br>UNITÉ                     | PREVIOUS<br>SHIPPED QUANTITY /<br>PRÉCÉDENT<br>Quantité livrée | MFG. PART NUMBER /<br>MFG. PARTIE NUMÉRO | ALLOY & TEMPER /<br>ALLIAGE & TEMPER | FINISH DESCRIPTION / DESCRIPTION DE FINITION | NBR OF<br>PKGS /<br>NBR DE<br>PKGS | GROSS LBS /<br>LIVRES BRUT                   | NET QUANTITY<br>/ QUANTITÉ<br>NETTE | UNIT /<br>UNITÉ                              | QUANTITY<br>DUE /<br>Quantité en<br>raison |
| 003  | 1,104 LB  |                                     |  | DAA-897123-1                             | 6061                                 |  | 2                                  | 1,204  | 1,173 LB                            |  |  |
|  | 501 KG  |                                     |  | D2622                                    | 120.0000 IN                          |  |                                    | 546  | 532 KG                              |  |  |
|  | 121 PC  |                                     |  |  | Cut(+): 0.0000 Cut(-): 0.0000        | Min: 0 % Max: 0 %                            |                                    |  | 126 PC                              |  |  |
|  |   |                                     |  |  |                                      | 802084 / 107783                              | 1                                  | 602  | 586                                 |  | 63 PC                                      |
|  |   |                                     |  |  |                                      | 802084 / 107784                              | 1                                  | 602  | 586                                 |  | 63 PC                                      |

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 1

|        |       |       |    |
|--------|-------|-------|----|
| 2      | 1,204 | 1,173 | LB |
|        | 546   | 532   | KG |
|        |       | 126   | PC |
| TOTALS |       |       |    |

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER